

Montagedrehmomente

| Progress MS, S2, S4 | | | Progress GFK | | | SYNTEC | | | mit Schutzfüllen | | | EMV Serie 85 | | |
|---------------------|--------------|---------|--------------|--------------|---------|---------|--------------|---------|------------------|--------------|---------|--------------|--------------|---------|
| Gewinde | Bereich (mm) | Md (Nm) | Gewinde | Bereich (mm) | Md (Nm) | Gewinde | Bereich (mm) | Md (Nm) | Gewinde | Bereich (mm) | Md (Nm) | Gewinde | Bereich (mm) | Md (Nm) |
| M6x1 | 2.0 - 2.5 | 2 | | | | | | | | | | | | |
| M6x1 | 2.5 - 3.0 | 1 | | | | | | | | | | | | |
| M6x1 | 2.0 - 3.5 | 1 | | | | | | | | | | | | |
| M8x1.25 | 2.5 - 3.5 | 2 | M8x1.25 | 2.5 - 3.5 | 1 | | | | M8x1.25 | 3.8 - 4.8 | 2 | | | |
| M8x1.25 | 3.0 - 5.0 | 1 | M8x1.25 | 3.0 - 5.0 | 1 | | | | | | | | | |
| M10x1.5 | 3.0 - 4.0 | 4 | M10x1.5 | 3.0 - 4.0 | 1 | | | | M10x1.5 | 4.0 - 6.0 | 3 | | | |
| M10x1.5 | 4.0 - 6.0 | 2 | M10x1.5 | 4.0 - 6.0 | 1 | | | | | | | | | |
| M12x1.5 | 3.5 - 5.0 | 4 | M12x1.5 | 3.5 - 5.0 | 2 | M12x1.5 | 2.5 - 6.5 | 1 | M12x1.5 | 4.0 - 6.0 | 5 | | | |
| M12x1.5 | 5.0 - 6.5 | 5 | M12x1.5 | 5.0 - 6.5 | 3 | | | | | | | | | |
| M12x1.5 | 6.5 - 8.0 | 3 | M12x1.5 | 6.5 - 8.0 | 2 | | | | | | | | | |
| M16x1.5 | 3.5 - 4.5 | 7 | M16x1.5 | 4.5 - 6.0 | 5 | M16x1.5 | 4.0 - 8.0 | 1 | M16x1.5 | 6.0 - 8.8 | 9 | M16x1.5 | 7.0 - 8.0 | 5 |
| M16x1.5 | 4.5 - 6.0 | 6 | M16x1.5 | 6.0 - 8.0 | 4 | | | | | | | M16x1.5 | 8.0 - 10.0 | 3 |
| M16x1.5 | 6.0 - 8.0 | 5 | M16x1.5 | 8.0 - 10.5 | 2 | | | | | | | M16x1.5 | 8.0 - 10.0 | 3 |
| M16x1.5 | 8.0 - 10.5 | 3 | M16x1.5 | 6.0 - 10.5 | 2 | | | | | | | M16x1.5 | 7.5 - 10.0 | 4 |
| M16x1.5 | 6.0 - 10.5 | 4 | | | | | | | | | | M16x1.5 | 8.0 - 12.0 | 5 |
| | | | | | | | | | | | | M16x1.5 | 8.0 - 12.0 | 5 |
| M20x1.5 | 6.0 - 8.0 | 10 | M20x1.5 | 6.0 - 8.0 | 6 | M20x1.5 | 3.0 - 7.0 | 3 | M20x1.5 | 9.0 - 11.0 | 11 | M20x1.5 | 11.0 - 15.0 | 5 |
| M20x1.5 | 8.0 - 11.0 | 9 | M20x1.5 | 8.0 - 11.0 | 5 | M20x1.5 | 5.5 - 12.0 | 4 | M20x1.5 | 10.5 - 13.0 | 10 | M20x1.5 | 11.0 - 15.0 | 5 |
| M20x1.5 | 11.0 - 15.0 | 5 | M20x1.5 | 11.0 - 15.0 | 2 | | | | | | | M20x1.5 | 14.0 - 17.0 | 5 |
| M20x1.5 | 8.0 - 15.0 | 5 | M20x1.5 | 8.0 - 15.0 | 3 | | | | | | | M20x1.5 | 14.0 - 17.0 | 5 |
| M25x1.5 | 9.5 - 12.5 | 10 | M25x1.5 | 9.5 - 12.5 | 6 | M25x1.5 | 8.0 - 14.0 | 7 | M25x1.5 | 13.0 - 16.5 | 31 | M25x1.5 | 15.0 - 20.5 | 4 |
| M25x1.5 | 12.5 - 16.0 | 10 | M25x1.5 | 12.5 - 16.0 | 4 | M25x1.5 | 11.0 - 18.0 | 10 | | | | M25x1.5 | 15.0 - 20.5 | 4 |
| M25x1.5 | 16.0 - 20.5 | 4 | M25x1.5 | 16.0 - 20.5 | 3 | | | | | | | M25x1.5 | 15.0 - 20.5 | 4 |
| M25x1.5 | 12.5 - 20.5 | 7 | M25x1.5 | 12.5 - 20.5 | 4 | | | | | | | M25x1.5 | 19.0 - 22.0 | 4 |
| | | | | | | | | | | | | M25x1.5 | 19.0 - 22.0 | 4 |
| M32x1.5 | 14.0 - 17.0 | 5 | M32x1.5 | 14.0 - 17.0 | 5 | M32x1.5 | 17.0 - 25.0 | 7 | | | | M32x1.5 | 21.0 - 25.5 | 4 |
| M32x1.5 | 17.0 - 21.0 | 4 | M32x1.5 | 17.0 - 21.0 | 4 | | | | | | | M32x1.5 | 21.0 - 25.5 | 4 |
| M32x1.5 | 21.0 - 25.5 | 4 | M32x1.5 | 21.0 - 25.5 | 3 | | | | | | | M32x1.5 | 22.0 - 28.0 | 8 |
| M32x1.5 | 17.0 - 25.5 | 6 | M32x1.5 | 17.0 - 25.5 | 4 | | | | | | | M32x1.5 | 26.0 - 32.0 | 9 |
| M40x1.5 | 20.0 - 24.0 | 10 | M40x1.5 | 20.0 - 24.0 | 10 | M40x1.5 | 22.0 - 33.0 | 10 | | | | M40x1.5 | 25.0 - 35.0 | 12 |
| M40x1.5 | 24.0 - 28.5 | 8 | M40x1.5 | 24.0 - 28.5 | 7 | | | | | | | M40x1.5 | 25.0 - 35.0 | 12 |
| M40x1.5 | 28.5 - 33.0 | 9 | M40x1.5 | 28.5 - 33.0 | 10 | | | | | | | M40x1.5 | 31.0 - 35.0 | 9 |
| M40x1.5 | 24.0 - 33.0 | 12 | M40x1.5 | 24.0 - 33.0 | 9 | | | | | | | | | |
| M50x1.5 | 29.0 - 33.0 | 11 | M50x1.5 | 29.0 - 33.0 | 11 | M50x1.5 | 28.0 - 38.0 | 23 | | | | | | |
| M50x1.5 | 33.0 - 37.0 | 14 | M50x1.5 | 33.0 - 37.0 | 12 | | | | | | | | | |
| M50x1.5 | 37.0 - 42.0 | 14 | M50x1.5 | 37.0 - 42.0 | 16 | | | | | | | | | |
| M50x1.5 | 33.0 - 42.0 | 22 | M50x1.5 | 33.0 - 42.0 | 15 | | | | | | | | | |
| M63x1.5 | 35.0 - 40.0 | 40 | M63x1.5 | 35.0 - 40.0 | 28 | M63x1.5 | 32.0 - 44.0 | 25 | | | | M63x1.5 | 31.0 - 35.0 | 14 |
| M63x1.5 | 40.0 - 46.0 | 39 | M63x1.5 | 40.0 - 46.0 | 19 | | | | | | | M63x1.5 | 35.0 - 45.0 | 22 |
| M63x1.5 | 46.0 - 52.0 | 33 | M63x1.5 | 46.0 - 52.0 | 41 | | | | | | | M63x1.5 | 35.0 - 45.0 | 22 |
| M63x1.5 | 40.0 - 52.0 | 38 | M63x1.5 | 40.0 - 52.0 | 26 | | | | | | | M63x1.5 | 35.0 - 45.0 | 22 |
| | | | | | | | | | | | | M63x1.5 | 35.0 - 45.0 | 22 |
| M75x1.5 | 45.0 - 50.0 | 53 | | | | | | | | | | | | |
| M75x1.5 | 50.0 - 56.0 | 42 | | | | | | | | | | | | |
| M75x1.5 | 56.0 - 63.0 | 43 | | | | | | | | | | | | |
| M75x1.5 | 50.0 - 63.0 | 50 | | | | | | | | | | | | |

Die angegebenen Drehmomente sind Maximalwerte für Druckmutter. Diese sind so lange anzuziehen bis das Drehmoment nach Tabelle erreicht ist ODER der Dichteinsatz einen leicht über die Druckmutter vorstehenden Wulst bildet. Zwischenstutzen (Verschraubungsunterteile) sollen mit dem grössten Drehmoment der jeweiligen Gewindegrösse angezogen und wenn nötig gegen unbeabsichtigtes Losdrehen gesichert werden.